

Date: Thursday, 5/4/2006 11:09:54 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BAR  
 Job Number : 26930  
 Estimate Number : 10388  
 P.O. Number : N/A  
 This Issue : 5/4/2006 S.O. No. : N/A  
 Prsht Rev. : NC  
 First Issue : N/A Type : MACHINED PARTS  
 Previous Run : N/A  
 Part Number : D31963  
 Drawing Number : D3196 REV A  
 Project Number : N/A  
 Drawing Revision : A  
 Material : N/A  
 Due Date : 5/19/2006 Qty: 8 Um: Each  
 Written By : SOMMANT BELOW  
 Checked & Approved By : JF 06.05.05  
 Comment : Est Rev: A New Issue 05-11-08 JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B0750X01500 6061-T6 Bar .75" X 1.5"



Comment: Qty.: 3.0345 f(s)/Unit Total: 24.2760 f(s)  
 Material: 6061-T6/T651 (QQ-A-200/8) or (QQ-A-225/8)  
 (M6061T6B0.750x01.500)  
 Identify for D3196-3  
 Batch: M101000

J.F. 06/05/18

8

2.0 BAND SAW BAND SAW



Comment: BAND SAW  
 Cut blank: (0.75" x 1.50") x 34.750" long Bar

JF 06/05/18

8

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine D3196-3 as per Folio FA339 and Dwg D3196 Identify as D3196-3

2-Deburr

ml 06/05/18

8

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml 06/05/18

8

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

ml 06/05/18

XP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: DP Date: 06/05/23  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 5/4/2006 11:09:54 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BAR

Job Number: 26930

Part Number: D31963

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

H.M 06/05/24

(8)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

A.m 06-05-25

(8)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

PU 4/5/25 (8)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST136

SL 06/05/26

(8)

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DP 06/05/29 (8)

Job Completion



U 06-05-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	26930
Description: Bar		Part Number:	D3196-3
Inspection Dwg: D3196	Rev: A	Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
34.625	+/-0.010	34.625	—			
33.650	+/-0.005	33.650	—			
0.488	+/-0.005	0.487	—			
17.011	+/-0.010	17.011	—			
0.512	+/-0.005	0.510	—			
1.500	+/-0.010	1.498	—			
0.464	+/-0.010	0.465	—			
0.504	+/-0.010	0.503	—			
Ø0.344	+0.005/-0.000	Ø0.348	—			
Ø0.660 x 100°	+/-0.005	Ø0.658x100	—			
0.962	+/-0.005	0.962	—			
0.750	+/-0.010	0.745	—			
4.750	+/-0.010	4.750	—			
12.531	+/-0.010	12.531	—			
16.999	+/-0.010	16.999	—			
21.844	+/-0.010	21.844	—			
29.625	+/-0.010	29.625	—			
0.250	+/-0.010	0.251	—			
1.000	+/-0.010	1.001	—			
R0.125	+/-0.010	R0.125	—			
0.987	+/-0.010	0.989	—			
0.060 x 45°	+/-0.010	0.055x45°	—			

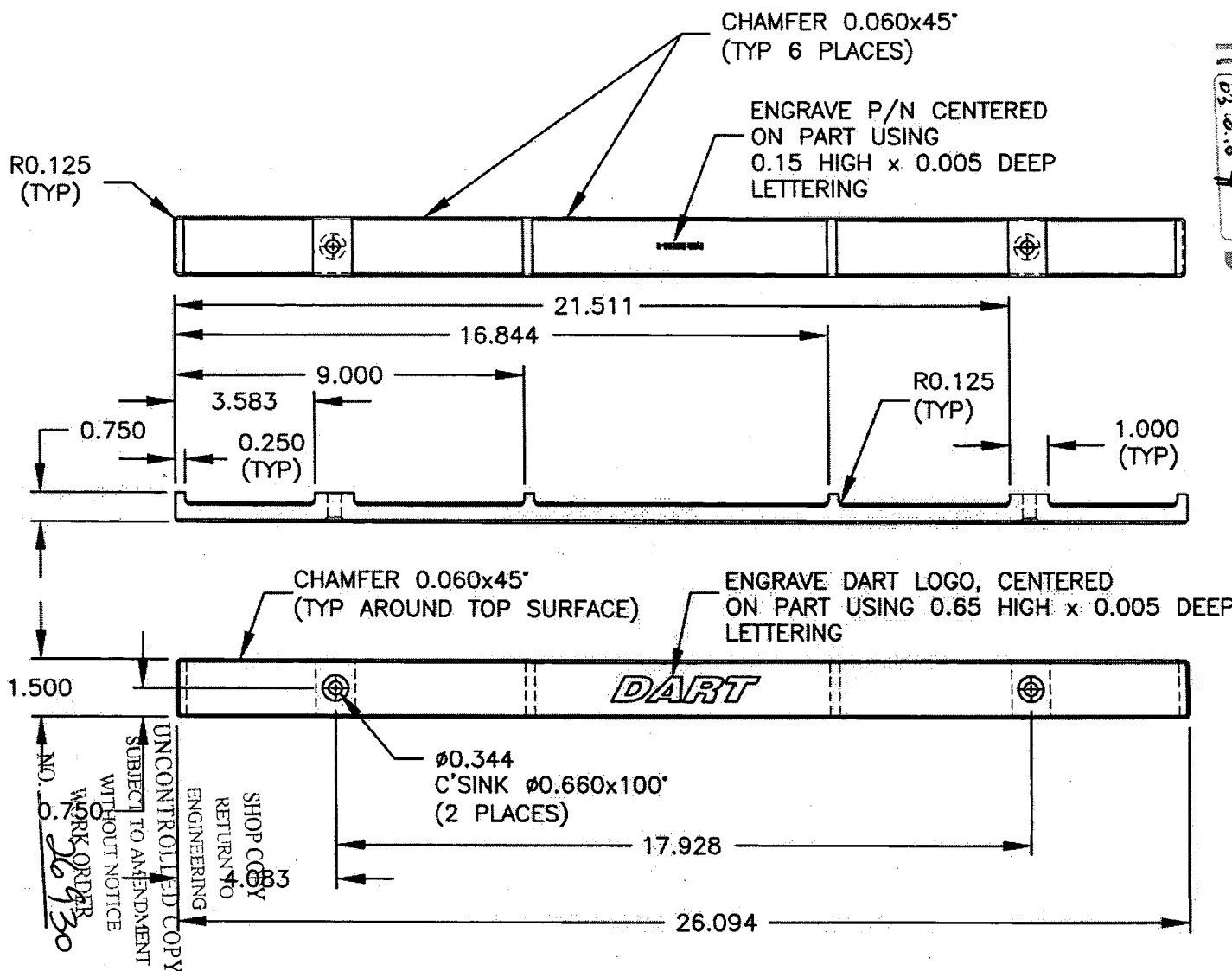
Measured by:	<i>ML</i>	Audited by:	<i>Sp</i>	Prototype Approval:	N/A
Date:	06/05/18	Date:	06/05/18	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.20	New Issue (P/O D412-702-011/-017)	KJ/RF <i>[Signature]</i>	<i>[Signature]</i>



RELEASED  
03.06.25

DESIGN	03.06.25	DRAWN BY	03.06.25	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED		APPROVED		REV. A
DATE	03.06.25	DRAWING NO.	D3196	SHEET 1 OF 3
TITLE	BAR	SCALE	1:4	
A		NEW ISSUE		



**D3196-1 BAR**

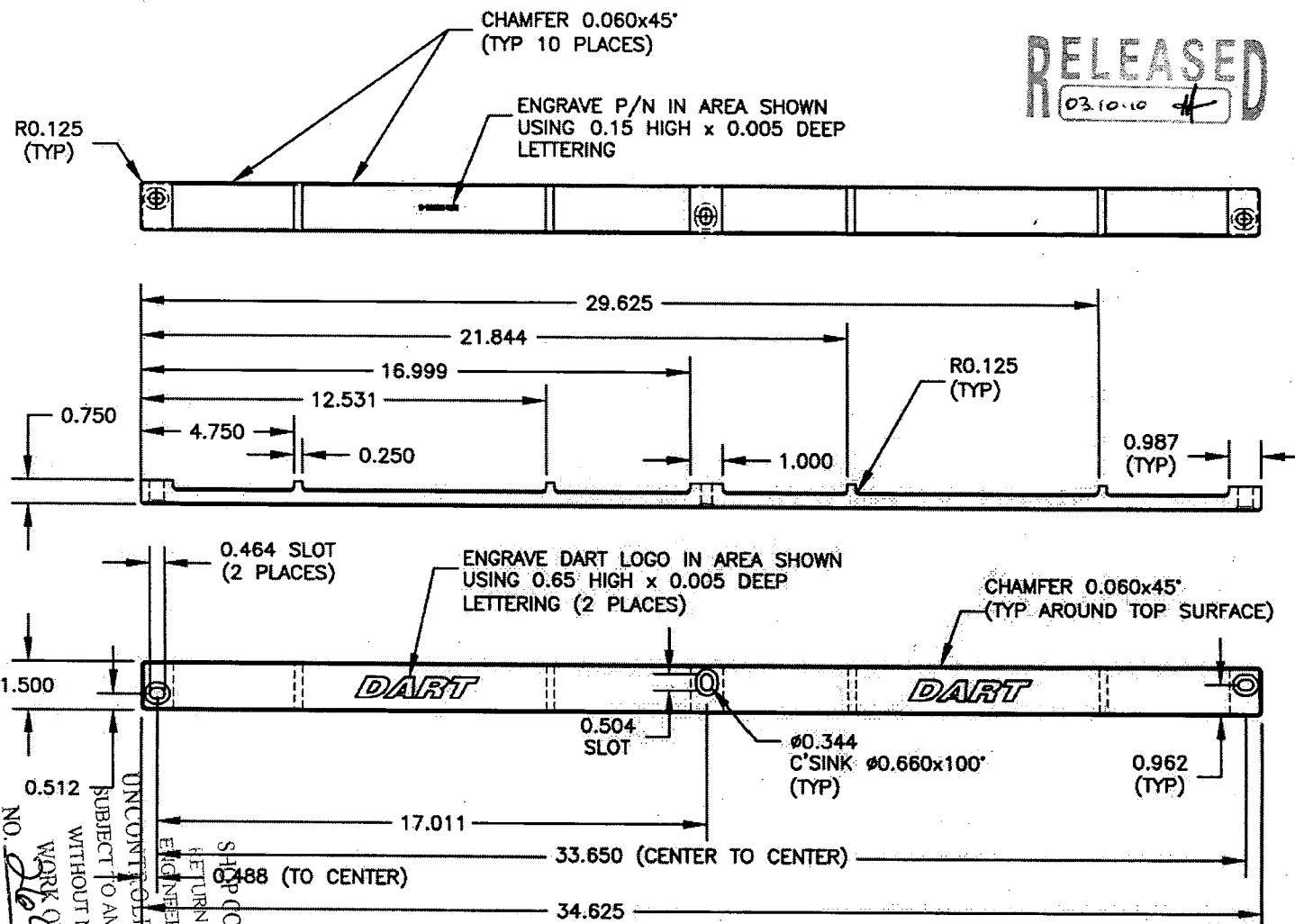
- 1) MATERIAL: 6061-T6/T651 ALUMINUM (QQ-A-200/8 OR QQ-A-225/8) (REF DART SPEC. M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

RELEASED  
03.10.10

**DART**



DESIGN	APPROVED	DRAWING NO.	REV. A
CHECKED	APPROVED	D3196	SHEET 2 OF 3
DATE	TITLE	SCALE	
03.06.25	BAR	1:5	



D3196-3 BAR

- 1) MATERIAL: 6061-T6/T651 ALUMINUM (QQ-A-200/8 OR QQ-A-225/8) (REF DART SPEC. M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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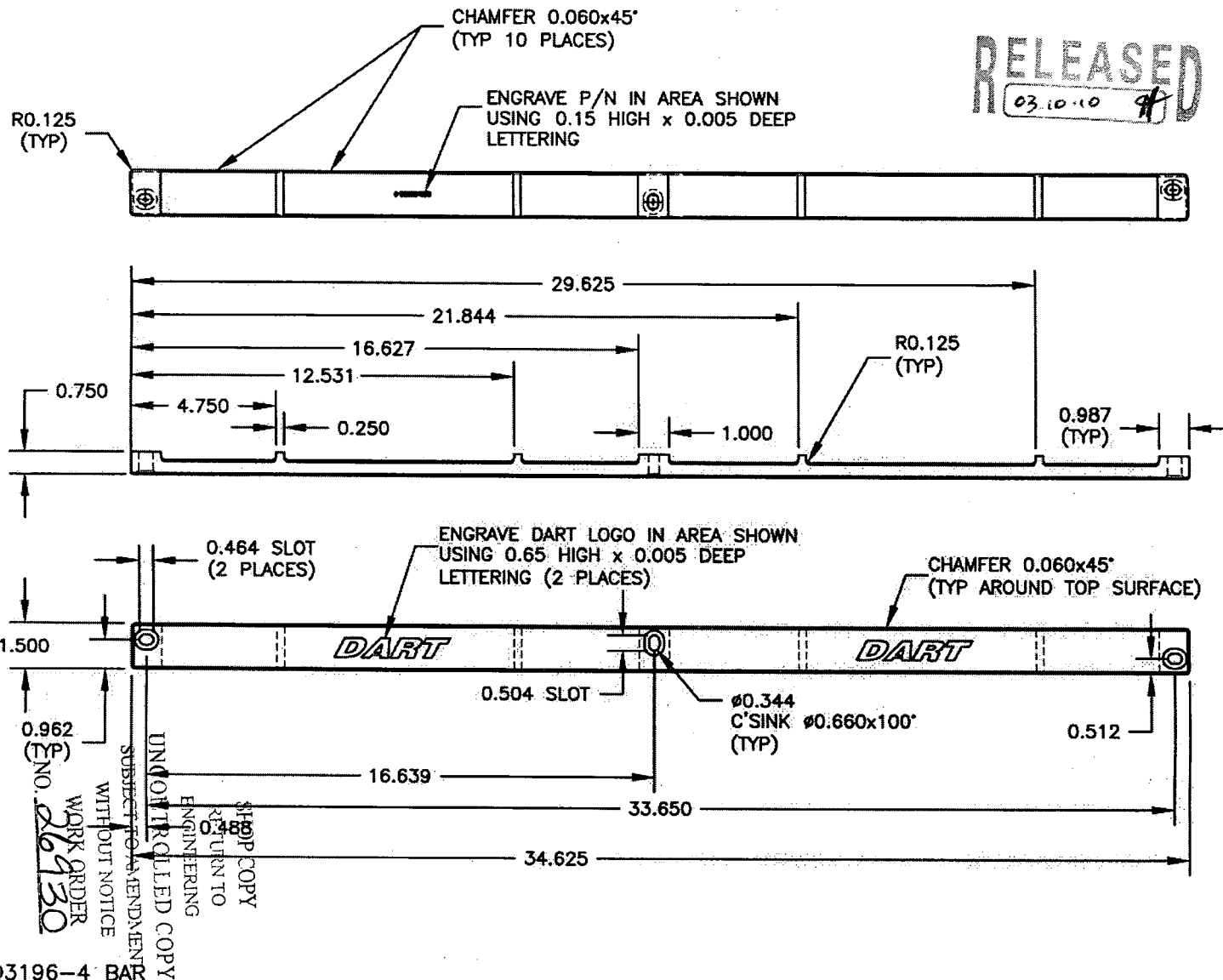
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RELEASED  
03.10.10

**DART**



DESIGN	DRAWN BY		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A	
DATE		D3196	SHEET 3 OF 3	
03.06.25		TITLE	SCALE	
		BAR	1:5	



D3196-4 BAR

- 1) MATERIAL: 6061-T6/T651 ALUMINUM (QQ-A-200/8 OR QQ-A-225/8) (REF DART SPEC. M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES